



**Lark Engineering Co. (India)**  
ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

**Inprocess Inspection (Pellet Dies)**

Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10776	48/48
2	Machined By		N.T.L. H/c Shop	Qty 48, 12.02.2013
3	Pellet Die No.		8517 (4.0) H/c	Rev-00
4	Die category	Drg. No.	Jumbo	
5	Outside diameter	Drg. No.	796 H/c, Step 60, 80 H/c	Tappes 4°
6	Inside Diameter	Drg. No.	700.12 H/c	Step length 37
7	Width Of Pellet Die	Drg. No.	320 H/c	Under cut = 9 H/c
8	Grooves As Per Drawing	Drg. No.	25x10x9 H/c / 25x10x9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		750 H/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 35.4 H/c	Tapping Depth 33.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/12/23	
1	As per programme no.		_____	
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 1 Hole Closed	
<b>Note:</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Rev: 44
2	External Relief Dia.	4.5 H/c	outside 23-31 / Inner	
3	External Relief Depth		4 H/c / Mill	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4/12/23	
Inspected By (Sign) & Date			Ravi 4/12/23	

*Sats*  
4/12/23  
Reviewed by (Engineer (CNC))

Manager-QA